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RBW1205G00332-3G

Job Sheet 172631



Part No: RBW1205G00332-3G

Job Qty: 1 ea

5065013

Part Name: Main Gear Box Oil Draining Hose



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/21/18

Job Tracking No:

Due Date: 3/16/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBW1205G00332-3G Rev 6 IPP Rev A 18.02.15 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		3/15/18	0.00	0.00	Start Up Small Fab-4		MLL
100	Small Fab	1 pcs		3/16/18	0.00	1.33	Small Fab-9		MLL
110	QC	1 pcs		3/16/18	0.00	0.00	QC5		EB
130	Packaging	1 pcs		3/16/18	0.00	0.00	Packaging3-2		APR 2 5 2018
140	QC21-FG	1 Ea		3/16/18	0.00	0.00	QC21		GA103

Part Op 100 - 1-Cut 9657K135 (-25) spring to 0.5" as per work order deviation 2-Assemble as per DWG sheet 1.
Descriptions: 130 - Identify and Stock

DAS
21
9-80

APR 2 6 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
2619 48	Spring Rnd 3/4" (Century Spring)	1 (1 ea)	90-Start up Operation	5057015
4464T123 26	O-Ring 9/16 Od X 1/16 Cross	1 (1 ea)	90-Start up Operation	5048577
81465	TBD	1 (1 ea)	90-Start up Operation	
91665A350 52	Retaining Ring, .7/16" Shaft	1 Ea (1 ea)	90-Start up Operation	5046089
K010-0608 125	Hose Ø1/2 OD x Ø3/8 ID x 12-1/2ft	6 ft (6 ea)	90-Start up Operation	
OET-1315 GA28	Hose Clamp - 1/2" Dixon Valve	1 (1 ea)	90-Start up Operation	5042369
RBW1205G00332-3G-01	Cap	1 Ea (1 ea)	90-Start up Operation	5061879
RBW1205G00332-3G-03	Quill	1 Ea (1 ea)	90-Start up Operation	5057095
RBW1205G00332-3G-17	Sleeve	1 Ea (1 ea)	90-Start up Operation	5059218
RBW1205G00332-3G-19	Barb	1 Ea (1 ea)	90-Start up Operation	5060923
RBW1205G00332-3G-21	Valve	1 Ea (1 ea)	90-Start up Operation	5059187
RBW1205G00332-3G-23	Screw (Modified B/O)	2 Ea (2 ea)	90-Start up Operation	OK
RBW1205G00332-3G-24	End Cap	1 Ea (1 ea)	90-Start up Operation	5062111
9657K135 47	Spring 245 stock GA47	1 Ea (1 ea)	90-Start up Operation	5047612

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	2619	1	0	0
	4464T123	1	0	0
	81465	1	0	0
	91665A350	1	0	0
	9657K135	1	0	0
	K010-0608	6	192	0
	OET-1315	1	0	0

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



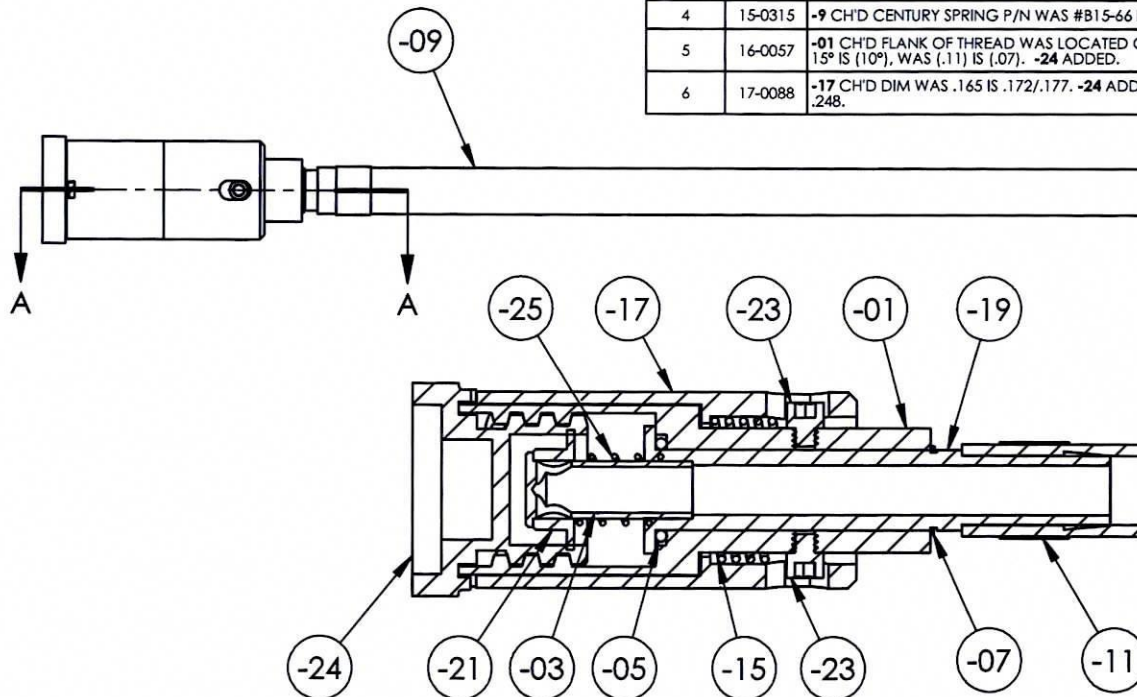
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐				
Date :	Step #:	QTY Effective :			MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			Completed By	
					Lead hand / Supervisor Approval Verification	
					QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY				
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	
OTHER : _____						

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		REDESIGNED WITH SHUTOFF AND RETAINING SLEEVE, ADDED PARTS -03, -17, -19, -21 & -23.	3/2/2011	JAG	
2		-01 CH'D TO CLEAR ANODIZE, THREAD CORRECTED TO 13/16-6. -03 CH'D HOLE FROM Ø.20, CH'D LIMIT DIM FROM Ø.3135 - .3139. -17 CH'D TO CLEAR ANODIZE. -19 CH'D HOLE DIA. FROM Ø.26 AND .10 FLANGE TO .06. -21 CH'D Ø.313 TO LIMIT DIM S.F.	11/30/2011	RJC	DW
3		-17 ADDED ENGRAVE NOTE. -23 CH'D O.D. FROM Ø.20 TO Ø.200 +.003 -.000.	2/15/2012	RJC	SE
3A		-13 DELETE, ENGRAVING IS ON -17.	5/2/2013	RJC	RJC
4	15-0315	-9 CH'D CENTURY SPRING P/N WAS #B15-66 IS #2619.	9/30/2015	RJC	JAG
5	16-0057	-01 CH'D FLANK OF THREAD WAS LOCATED ON CENTERLINE IS OFFSET 13° FROM CENTERLINE; WAS 15° IS (10°), WAS (.11) IS (.07). -24 ADDED.	6/16/2016	SM	JAG
6	17-0088	-17 CH'D DIM WAS .165 IS .172/.177. -24 ADDED DIM'S .696, Ø1.09, MIN. R. DELETED DIM'S 2X .068, .248.	4/17/2017	RJC	JAG



SECTION A-A
SCALE 1 : 1

NOTE:
FUNCTION: PART OF HELICOPTER SERVICING KIT PART No 3G1205G00131. USED TO DRAIN OIL FROM THE MGB THROUGH THE PARKER STRATOFLEX COUPLING, RBW1205G00332-3G REPLACES STRATOFLEX (11362) (A3Q07) P/N 165006.

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-01	1	CAP	6061		2
			-03	1	QUILL	303/304 S.S.		3
		B/O	-05	1	O-RING	BURNA-N	9/16 OD X 1/16 CROSS (MCMaster-CARR #4464T123)	1
		B/O	-07	1	EXTERNAL RETAINING RING	SPRING STEEL	Ø7/16 SHAFT MCMaster-CARR #91665A350	1
		B/O	-09	1	HOSE	VINYL	Ø1/2 X 3/8 X 6 FT. KURI-TECH #K010-0608	1
		B/O	-11	1	CRIMP HOSE CLAMP	S.S.	Ø1/2 DIXON VALVE #OET-1315	1
		B/O	-15	1	SPRING	SPRING STEEL	Ø3/4 CENTURY SPRING #2619	1
			-17	1	SLEEVE	6061		4
			-19	1	BARB	303/304 S.S.		5
			-21	1	VALVE	303/304 S.S.		6
			-23	2	SCREW	S.S.	6-32 X 1/8 (MCMaster-CARR #92196A139) MODIFIED	7
			-24	1	END CAP	6061		8
		B/O	-25	1	SPRING	MUSIC WIRE	Ø.028 WIRE: Ø.360 OD X .5 FREE LENGTH RIED #S1165	1

DART
AEROSPACE

TITLE
MAIN GEAR BOX DRAIN TOOL

DWG NO. RBW1205G00332-3G

REV
6

MAT'L	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
FEAT	.XXX ± .005 FRACTIONS ± 1/8
FINISH	.XX ± .01 ANGLES ± .5°
SPEC	.X ± .1 SURFACES = 125/
DRAWN BY: PERRITT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	AGUSTA
SCALE 1:2	DATE 2/23/2011
	SHEET 1 OF 8